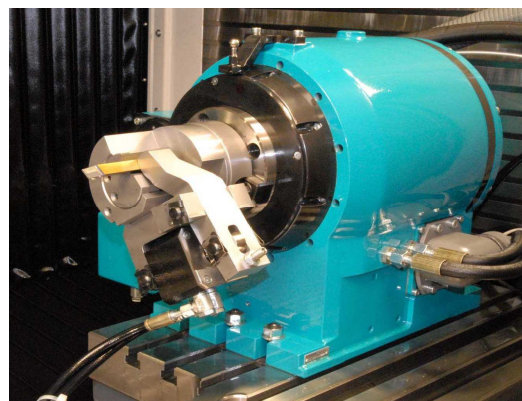













Gear Blade Oerlikon

A12-350

The profiled Gear Blades are ground with DXF based Profileoperation being clamped horizontally in a specially designed automatic clamping device. The 1A1-wheel is used on both sides to grind either the pressure side of the blade or the clearance side of the blade and the cutting face.



1. Cycletime for Resharpening

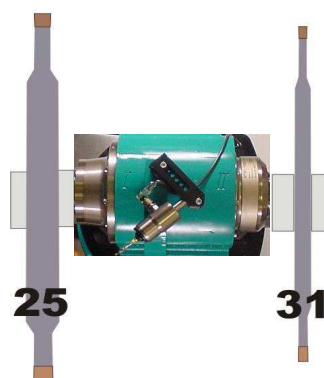
Tool specifications inner blade and outer blade 469; 14 x 17 x 115 mm Material HSS						
Operations						
Feed [mm/Min]	2000	85	85	90	90	80
Power [kW]		1.5	1.5	0.7	0.7	0.9
Cutting feed [m/s]		28	28	32	32	28
Used wheels						
Grinding time [s]	18	36	36	28	28	32
Total cycle time	2 Min 58					

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.



2. Used Grinding Wheels

25 Ø250 1A1 B181
31 Ø250 14A1 B54



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NGC
Control: Fanuc 31i B5
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5

Responsible engineer: 31.10.2014, ADA

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